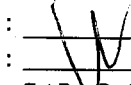
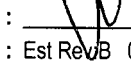


Date: Friday, 04/01/2008 9:23:16 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	OH-58 STEP ASSY RH *UNDER REVIEW**
Job Number :	36563	Part Number :	D058677012
Estimate Number :	12439	Drawing Number :	D2943 UNDER REVIEW
P.O. Number :		Project Number :	N/A
This Issue :	04/01/2008	Drawing Revision :	UNDER R
Prsht Rev. :	NC	Material :	
First Issue :	04/01/2008	Due Date :	11/01/2008
Previous Run :	31294	Qty:	4
Written By :		Um:	Each
Checked & Approved By :			
Comment :	Est Rev B 01.04.11 Combined with D2943-041 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPPD058-677-012 CHG001

5 08/01/05 08.01.10

2.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Extrusion D2622-120C
Batch: B2622120C B35618

SAD 08/01/10 (4)

3.0	D2734	206 Step Endplate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
D2734 206 Step Endplate
Batch: 334485

SE 08.01.10 4

4.0	D2725	206 Step Lug
-----	-------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
D2725 206 Step Lug
Batch: 336274

SE 08.01.10 4

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

SAD 08/01/10 (4)

2-Deburr and bevel ends for welding

SAD 08/01/10 (4)

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8483

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/01/2008 9:23:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY RH *UNDER REVIEW**

Job Number: 36563

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL ROD

Batch: M105844

PL 08-01-15 4

4-Grind end cap welds flush as per dwg D2943

SAD 08-01-15 4

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-15 (4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-15 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08-01-17 (4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 08-01-17 (4)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch: M105058

PL 08-01-17 4

2-Grind end cap welds flush as per dwg D2943

SAD 08-01-18 (4)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-22 (4)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PL 08-01-22 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/01/2008 9:23:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY RH *UNDER REVIEW**

Job Number: 36563

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Pressure wash as per QSI 005

2-Touch up Chemical Conversion Coat as per QSI 005 4.1

→ BK 08-01-23 (H)

14.0

POWDER COATING

POWDER COATING



M 106379



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/01/24

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M 106332

FL 08/01/24 (F)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/25 (4X012)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/25 (4X012)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Lug

Batch:

B 34530 (2x) B 27419 (4x)

SP

20.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Lug

8/1/24 SP (4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/01/2008 9:23:17 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY-RH *UNDER REVIEW**

Job Number: 36563

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Lug

Batch: 132591

SP

22.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Lug

Batch: 1333420 (2x)

1334125 (6x)

SP

23.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: 1104214

SP

24.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

1105143

SP

25.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Batch: 1106277

SP

26.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Nut

Batch: 1105938

8/1/24

SP

(4x)

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5

08/01/25 + 9 PK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/01/2008 9:23:17 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY RH *UNDER REVIEW**

Job Number: 36563

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-012

Location:

PPP Rev:

B

AS 08/01/25 (X4)
08.01.25

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.01.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

PORI HADLUCK, WA

२

DRAWN BY

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

ED

APPROVED

DRAWING NO

REV. B



5

02343

SHEET 1 OF 1

05.11.14

1000

04-58

NTS

A

99.11

NEW IS

B

05.11

UPDATE

8

UNDER REVIEW

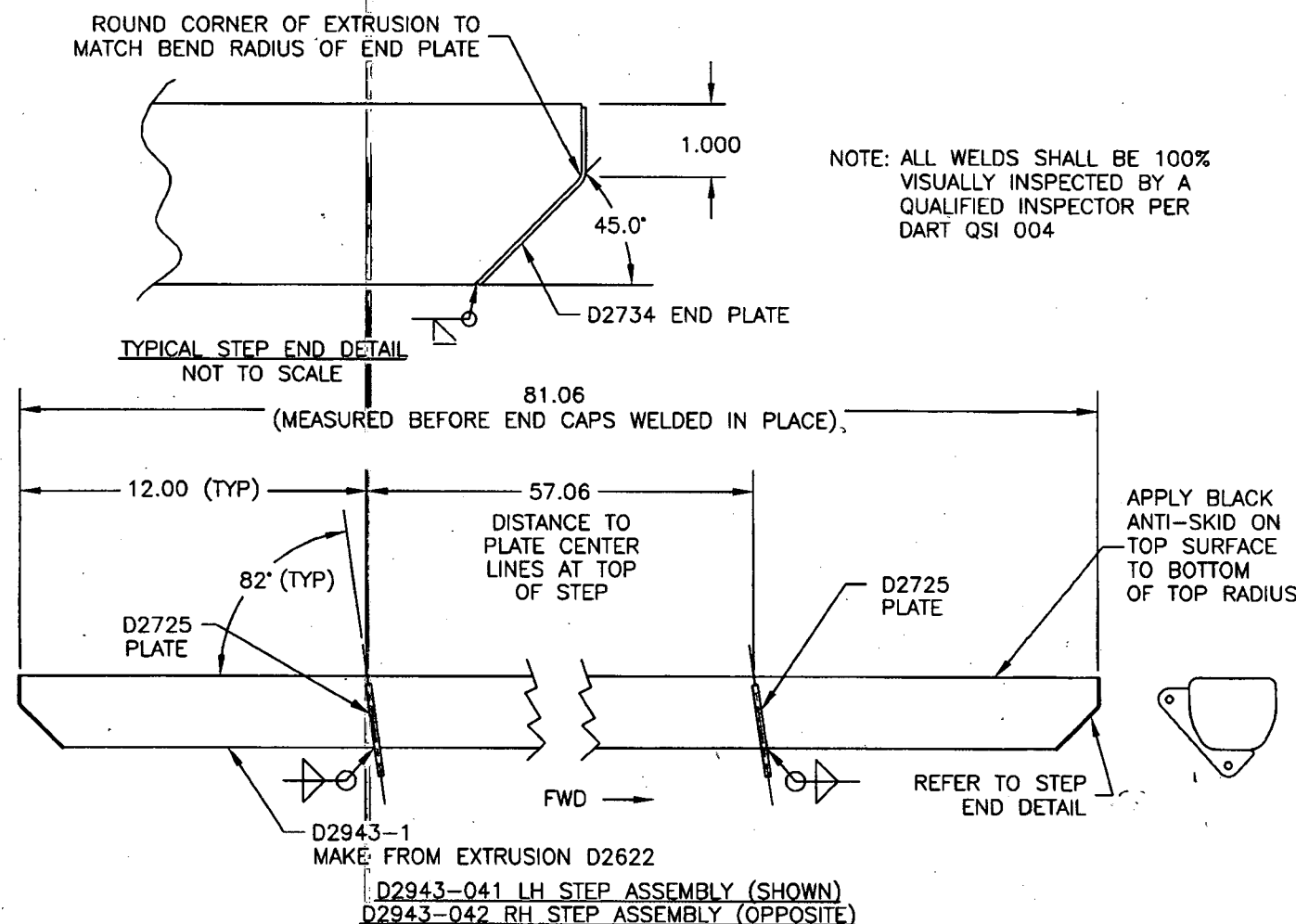
06-03-29 BHT

RE-DESLGN
JANUARY TO 0206-608

05-11-28-~~117~~

W/O
36563

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*cut per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 020-010 0117 012 011 00 0117 ASSEMBLY NOTES
- 1) MAKE FROM EXTRUSION D2622
 - 2) WELD PER DART QSI 004
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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